

Work Order ID 72183

Tuesday, July 19, 2011 2:29:44 PM

SPLIT -



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: 11-07-19 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
TRIM RIVETS 1.185" LONG

0.00

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 11/07/29

SB 11/07/29

SB 11/07/29

(4C)

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Item ID: D3908-041

Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011 Start Qty: 1.00

Required Date: 7/21/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 471

0.00

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

4/18/12

ck 11/08/02

11-02-8

# Picklist Print

Page 1

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Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft



Start Date: 7/19/2011

Start Qty: 1.00

Required Date: 7/21/2011

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD  
10.05.27 DD verf:EC  
10.05.28 DD verf:EC  
IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	40.0000	1	1		7/21/2011	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST020		40							
				70920		40							
D3908-1  Lug Plate, Aft Crosstube		Manufactured	No			100	Each	17.0000	2	2		7/21/2011	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST090		17							
				66167		3							
				68259		14							
D3908-3  Stud Receiver, Lower		Manufactured	No			100	Each	13.0000	1	1		7/21/2011	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST090		13							
				66172		5							
				68260		8							

# Picklist Print

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Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3908-5 Manufactured No

100 Each

15.0000



Eyebolt Stud

Location

Loc Qty

Loc Code

GA

1

57428

1

ST090

14

59670

2

65625

8

66185

4

D3910-1

Manufactured No

100 Each

32.0000



Crosstube Lug

Location

Loc Qty

Loc Code

ENG

30

70160

30

st507

2

68263

2

D4091-1

Manufactured No

100 Each

22.0000



Mounting Lug

Location

Loc Qty

Loc Code

ST460

22

69605

22

AN3C12A

Purchased No

100 Each

24.0000



Bolts

Location

Loc Qty

Loc Code

ST351

24

117514

4

118112

20

M118422

①

15

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Shop Packet Print

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Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No



BOLT

Location

Loc Qty

Loc Code

ST357

23

117793

23

100

Each

16.0000



1

EP 11/07/20

MS17984-C413 Purchased No



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

16

114340

1

117557

15

100

Each

100.0000



1

EP 11/07/20

MS20615-4420 Purchased No



RIVET

Location

Loc Qty

Loc Code

GA

100

117071

100

100

Each

776.0000



2

EP 11/07/20

MS21043-3 Purchased No



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

704

112314

33

118077

671

EP 11/07/20

2 16

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# Picklist Print

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Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly. Aft



Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No



Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	587	
117601	87	
117793	500	

627.0000



1 1  
GB 11/07/20

NAS1149C0332R Purchased No



Washer

Location	Loc Qty	Loc Code
FP-B	7	
117291	7	
ST297	8644	
116304	55	
117460	62	
117887	247	
118078	2	
118179	86	
118306	3192	
118354	5000	

8.651.000



4 4  
GB 11/07/20

NAS1149C0432R Purchased No



Washer

Location	Loc Qty	Loc Code
ST297	4920	
116900	302	
117291	4618	

4,920.000



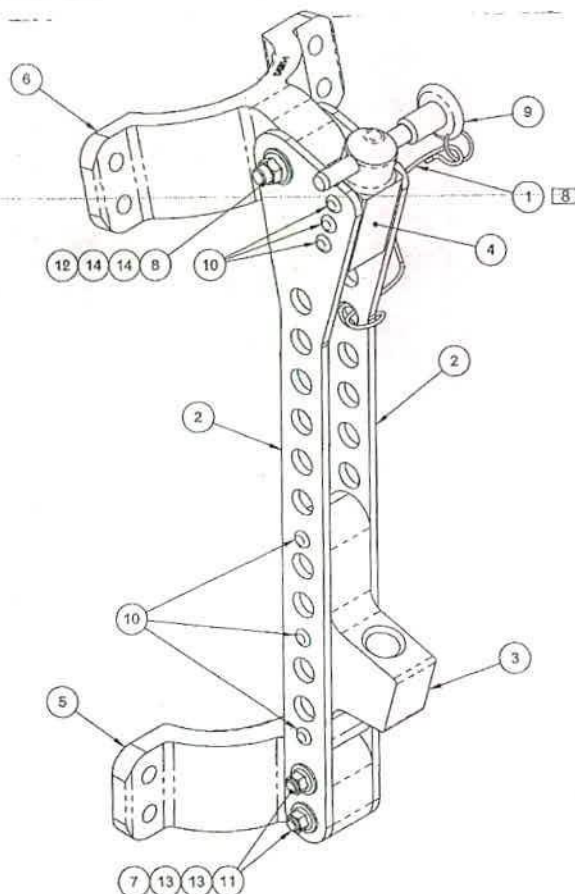
2 2  
GB 11/07/20

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Shop Packet Print

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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20815-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



**D3908-041 X-TUBE LUG ASSY (AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

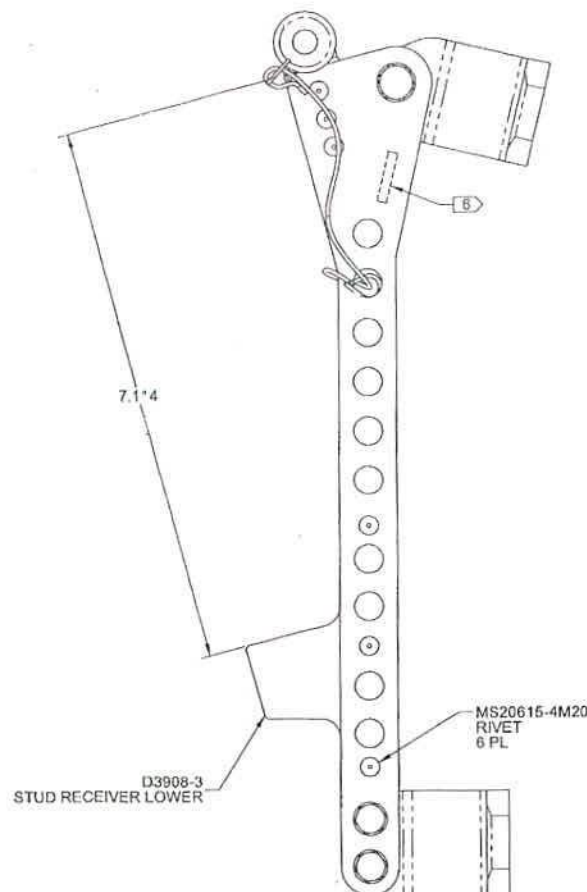
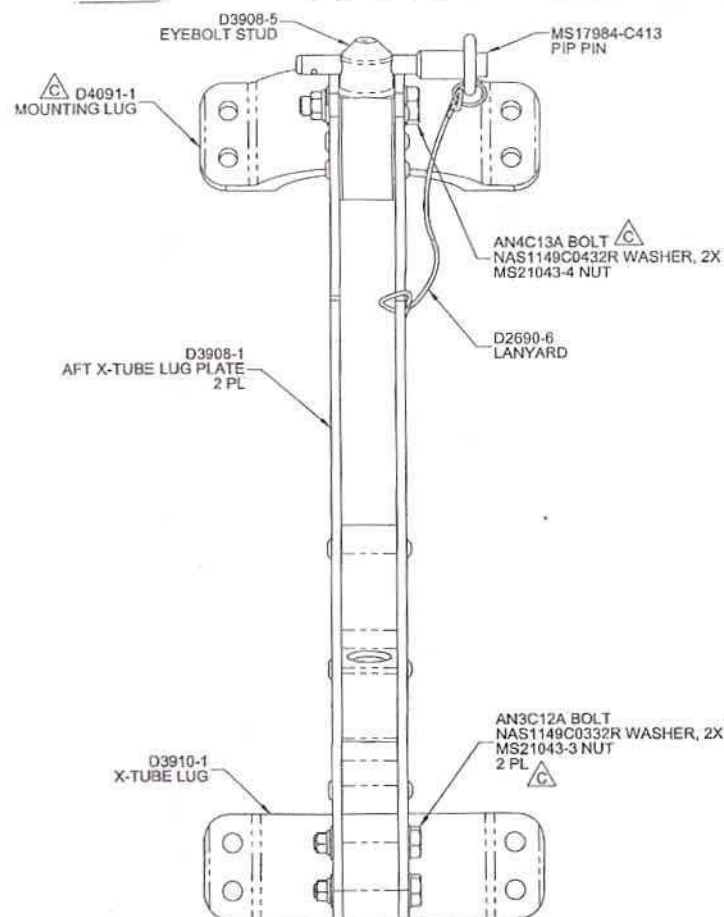
**RELEASED**  
2010-05-28

C	REDESIGNED ITEM #2: ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3909-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3908** REV. C  
SHEET 1 OF 5  
TITLE: **X-TUBE LUG ASSY (AFT)** SCALE: NTS

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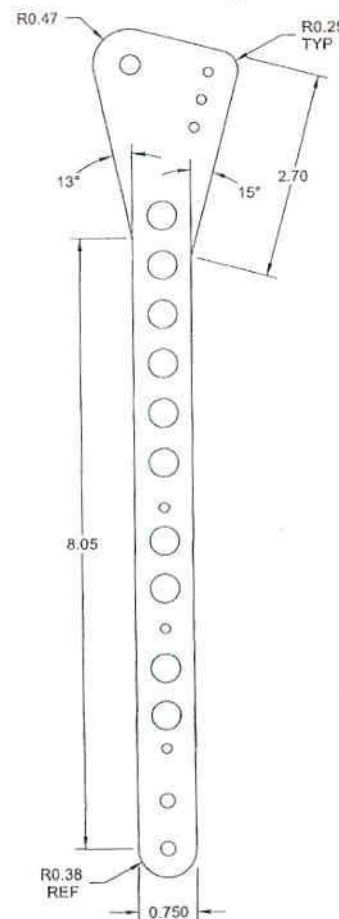
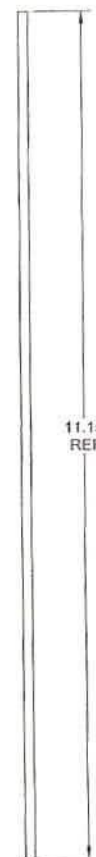
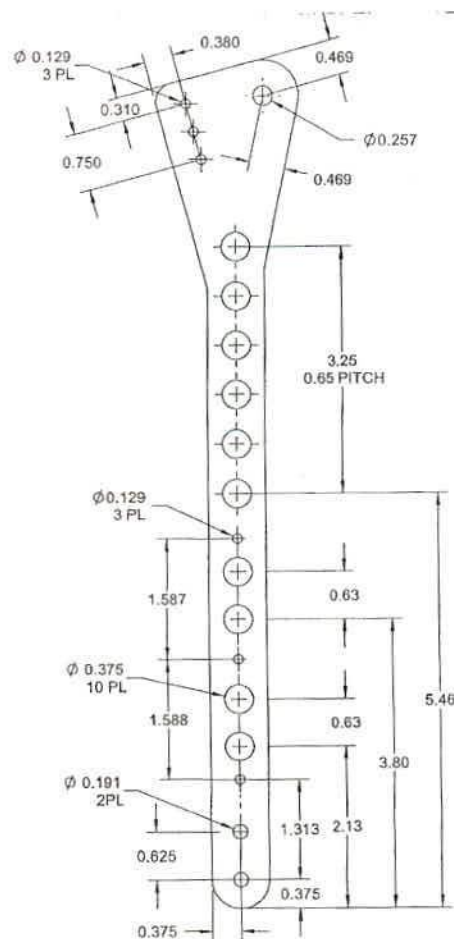
**D3908-041 X-TUBE LUG ASSY (AFT)**

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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# 72183

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2010-05-28  
JMP





#72083

RELEASED  
2010-05-28  
MP

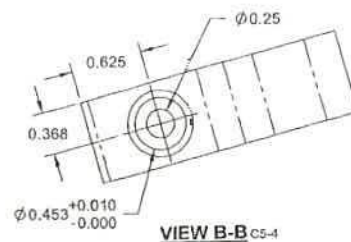
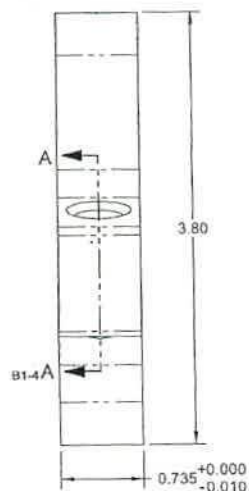
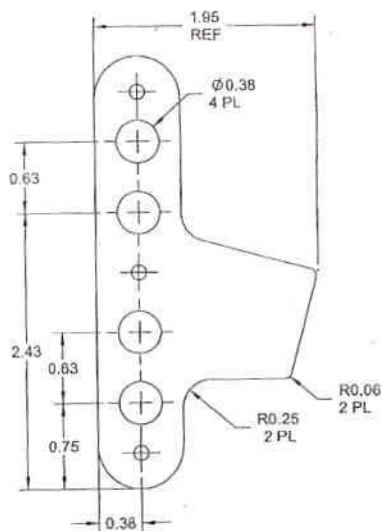
# NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

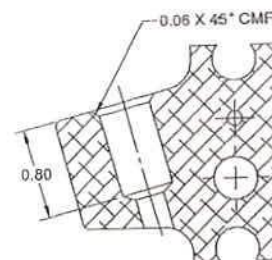
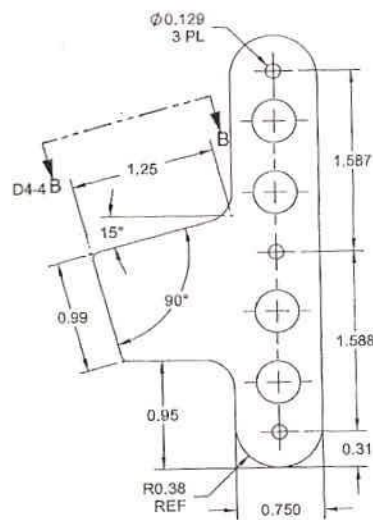
## D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DATE	10.05.27	X-TUBE LUG ASSY (AFT)	NTS

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VIEW B-B C5-4



SECTION A-A B6-4

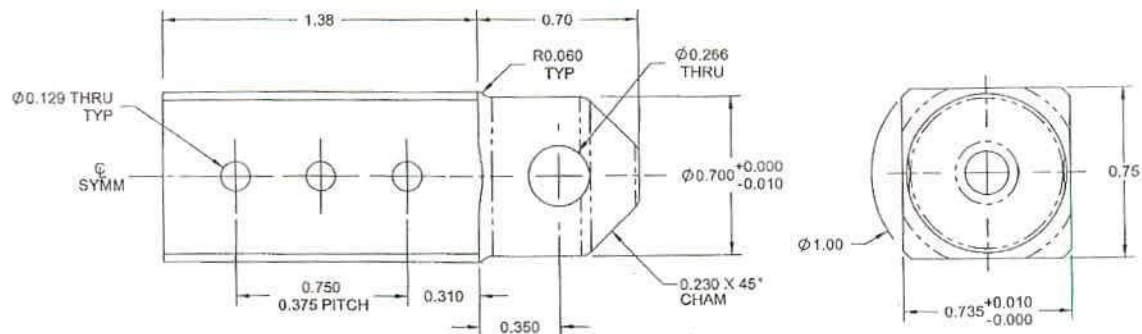
RELEASED  
2010-05-28

D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	



**D3908-5 EYEBOLT STUD**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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